

Work Order ID 80750

80750

Page 1

February-28-12 1:16:25 PM

Item ID: D4278-045

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Rib Assembly, Fwd Cham

Stop *NS2*

Start Date: 28/02/2012 Start Qty: 2.00

1

Cust Item ID:

Required Date: 13/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/02/28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D4277

D

D4278

C

100 Weld per dwg A/R S.S. rod Batch 1114509 0.00

100

Large Fab

Memo

0.00

Large Fab

1- Assemble ribs and weld as per dwg

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

4

12-5-17

4x Ø 12.05.17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 80750

February-28-12 1:16:25 PM

80750

Page 2

Item ID: D4278-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly, Fwd Cham
 Start Date: 28/02/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 13/03/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

| | | | | | | | | | |
|--------------|---|------|--|--|--|--|--|--|--|
| 130 | Identify as per dwg & Stock Location: <u>WA</u> | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | ***STOCK IN BASKET CELL*** | | | | | | | | |

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 140 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

Handwritten notes and signatures:

- QC (circled)
- 4x Ø
- PC 12-05-17
- 12/5/17
- MR
- 12-05-17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR#: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

February-28-12 1:16:29 PM

Page 1

Work Order ID: 80750

80750

Parent Item: D4278-045

D4278-045

Parent Item Name: Rib Assembly, Fwd Cham

Start Date: 28/02/2012

Required Date: 13/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 10.11.12 new issue DD verf:EC
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D4277-11 *D4277-11* Rib | | Manufactured | No | | | 100 | Each | 2.0000 | 1 | 21 | | EL 12-5-17 | |
| | | | | | | | | | ** | | | | |
| | | | | | <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | | |
| | | | | | WA | 2 | | | | | | | |
| | | | | | 74279 | 2 | P 84178 | | | | | | |
| D4277-7 *D4277-7* Rib | | Manufactured | No | | | 100 | Each | 0.0000 | 1 | 1 | | 12-5-17 | |
| | | | | | | | | | ** | | | | |
| | | | | | | | | | | 383963 | x4 | | |

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NOTE: Date & initial all entries

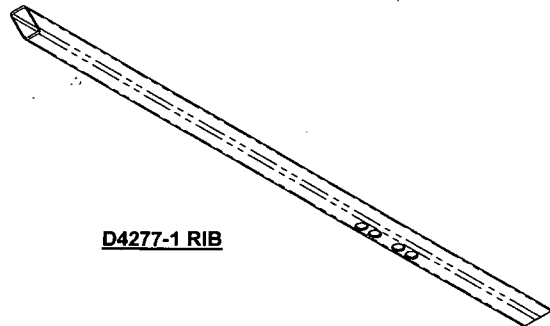
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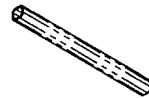
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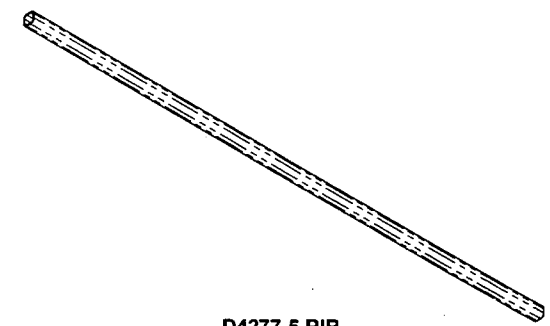
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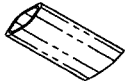
D4277-1 RIB



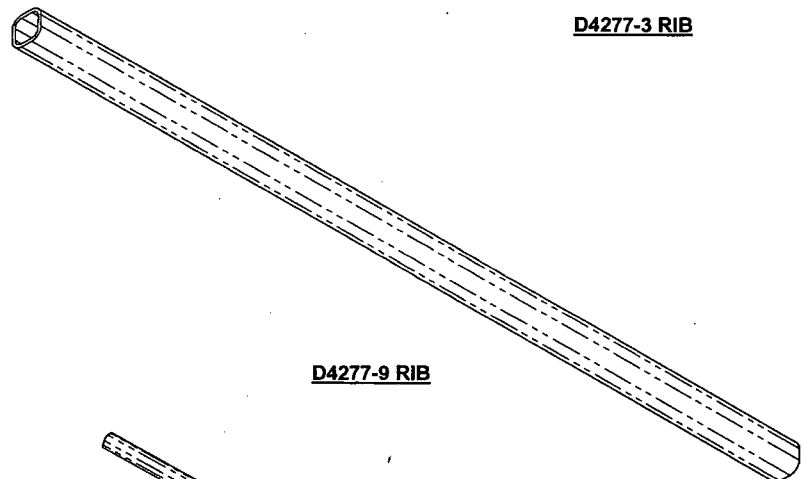
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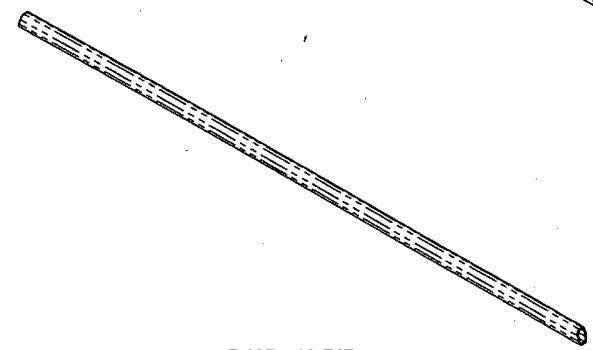
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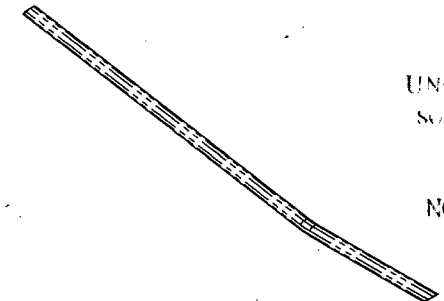
D4277-7 RIB



D4277-9 RIB



D4277-19 RIB



D4277-11 RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 80750 *MLJ*

12/02/28

RELEASED
2011-02-24
AWD

| | | | |
|------------|--|---|--------------|
| D | CHANGED ANGLE FROM 71° TO 61° (B3-3) | SC | 11.02.09 |
| C | D4277-19 RIB ADDED, ADDITIONAL HOLES ADDED IN D4277-1 | SC | 10.12.23 |
| B | RMV -13/-15/-17 (OBSOLETE); -3: 6.09 WAS 20.25 (CS-2); -9: 13.50 WAS 2.00 (B4-2); -5: 24.25 WAS 20.25 (B5-2) | CP | 10.11.30 |
| A | NEW ISSUE | SC | 10.11.25 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. D |
| MFG. APPR. | <i>[Signature]</i> | D4277 | SHEET 1 OF 3 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | RIBS | NTS |
| DATE | 11.02.09 | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | |

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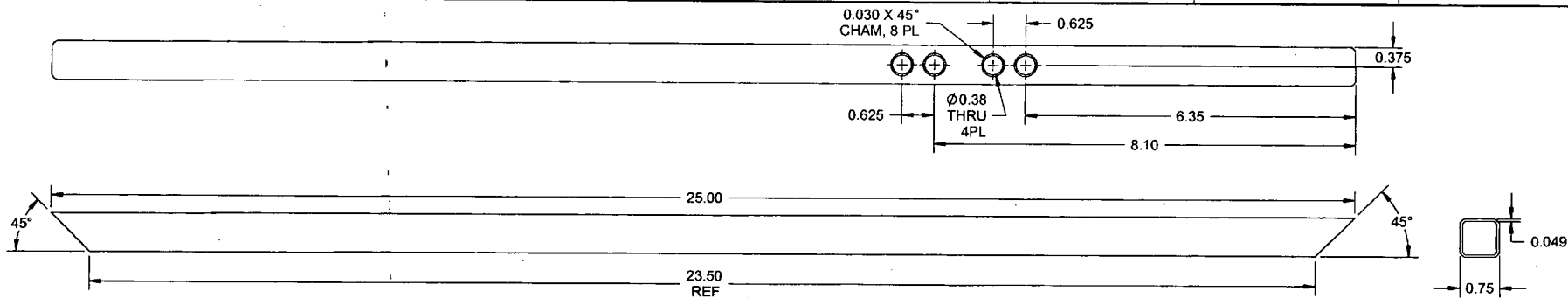
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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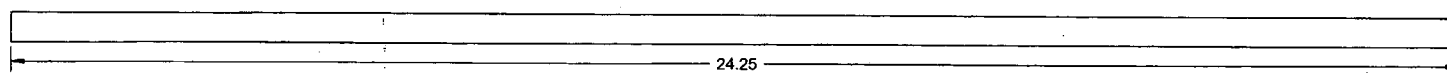
NOTE: Date & initial all entries



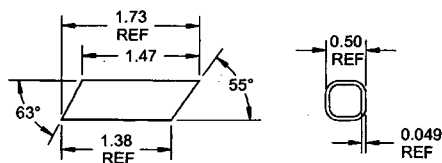
D4277-1 RIB



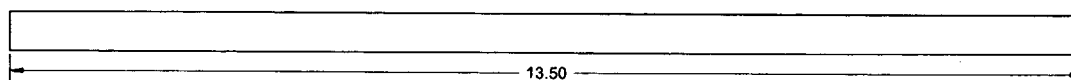
D4277-3 RIB



D4277-5 RIB



D4277-7 RIB



D4277-9 RIB

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL
 - 1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
 - 3, -5, -7, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

| | | | |
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| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D4277 | SHEET 2 OF 3 |
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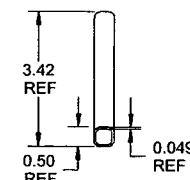
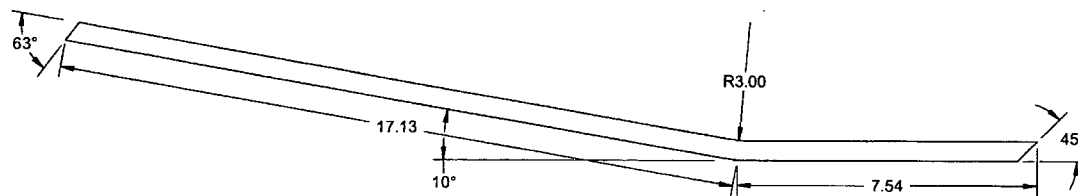
| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

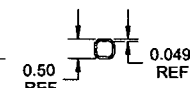
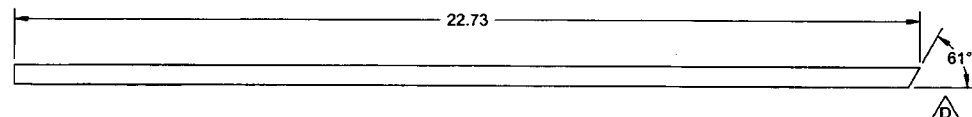
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NOTE: Date & initial all entries



D4277-11 RIB

80750



D4277-19 RIB

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL -11, -19: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS.

| | | | |
|------------|----------|--|--------------|
| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | K | DRAWING NO. | REV. D |
| MFG. APPR. | | D4277 | SHEET 3 OF 3 |
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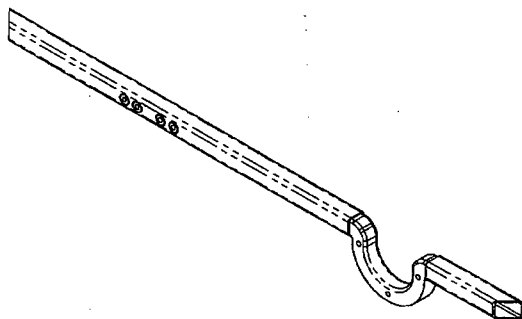
| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

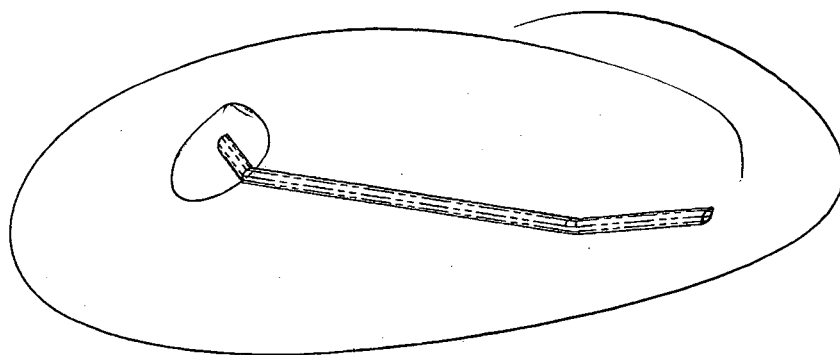
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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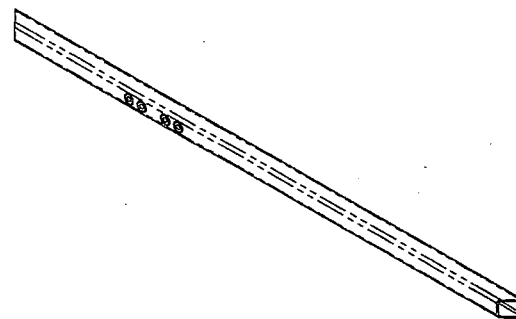
NOTE: Date & initial all entries



D4278-041 UPPER RIB ASSY-HOOP



D4278-045 RIB ASSY, FWD CHAM



D4278-047 UPPER RIB ASSY-STRAIGHT



UNCONTROLLED COPY
SUBJECT TO AND GOVERNED BY
WITHOUT
WORK ORDER
NO. 80750

RELEASED
2011-01-18
M

| C | ADDITIONAL HOLES ADDED IN D4278-041/-047 | SC | 10.12.23 |
|------------|--|--|--------------|
| B | RMV -043 (OBSOLETE) | CP | 10.11.30 |
| A | NEW ISSUE | SC | 10.11.25 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D4278 | SHEET 1 OF 4 |
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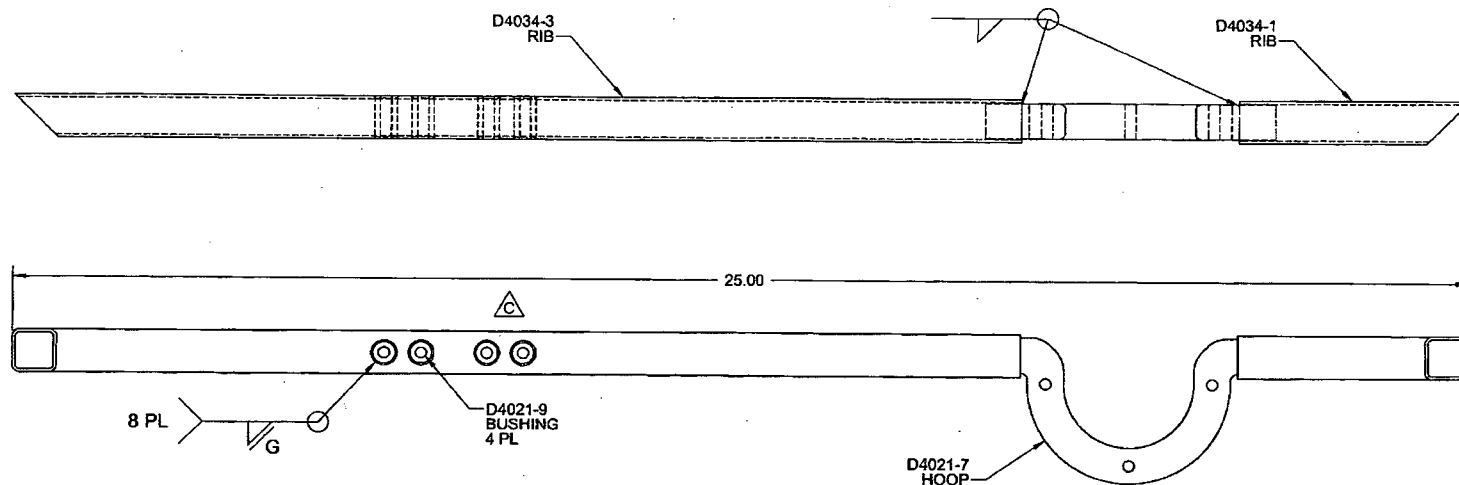
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

| ITEM | QTY | PART NUMBER | DESCRIPTION |
|------|--------------|-------------|---------------------|
| | 1 | D4278-041 | UPPER RIB ASSY-HOOP |
| 1 | 1 | D4021-7 | HOOP |
| 2 | 4 | D4021-9 | BUSHING |
| 3 | 1 | D4034-1 | RIB |
| 4 | 1 | D4034-3 | RIB |



D4278-041 UPPER RIB ASSY-HOOP

RELEASED
2011-01-18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

| | | | |
|------------|----------|--|--------------|
| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D4278 | SHEET 2 OF 4 |
| APPROVED | | TITLE | SCALE |
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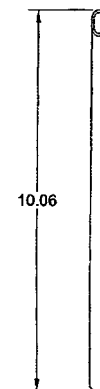
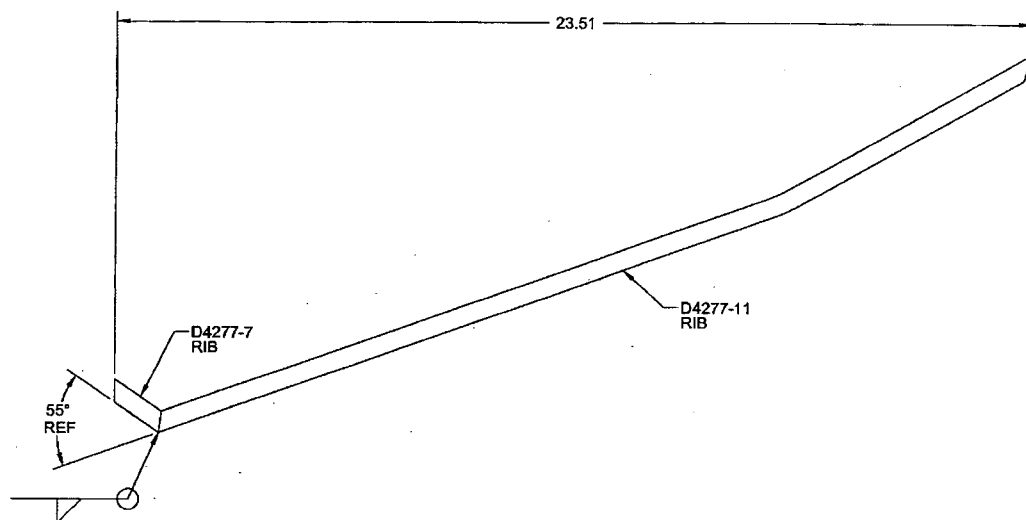
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| ITEM | QTY | PART NUMBER | DESCRIPTION |
|------|------|-------------|-----------------------|
| | -045 | | |
| | | D4278-045 | RIB ASSY, FWD CHAM |
| 1 | 1 | D4277-7 | MID CORNER RIB, NOTCH |
| 2 | 1 | D4277-11 | MID DIAG RIB |



80750

D4278-045 RIB ASSY, FWD CHAM

RELEASED
2011-01-18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.57 lbs
- 8) WELD PER DART QSI 004.

| | | | |
|---|----------|--|--------------|
| DESIGN | JRH | DART AEROSPACE LTD | |
| DRAWN | SC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D4278 | SHEET 3 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | RIB ASSEMBLY | NTS |
| DATE | 10.12.23 | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

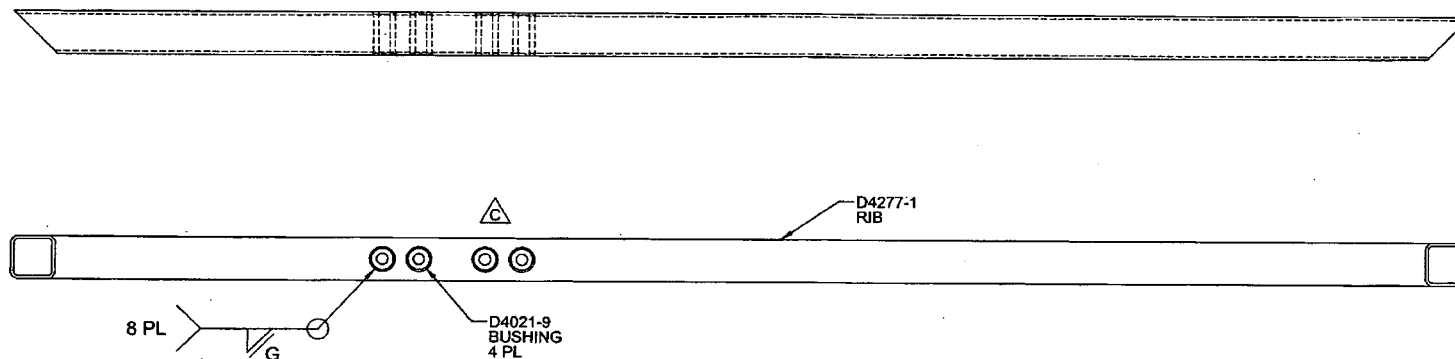
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| ITEM | QTY | PART NUMBER | DESCRIPTION |
|------|--------------|----------------------|------------------------------------|
| | 1 | D4278-047 | UPPER RIB ASSY-STRAIGHT |
| 1 | 4 | D4021-9 | BUSHING |
| 2 | 1 | D4277-1 | RIB |



D4278-047 UPPER RIB ASSY-STRAIGHT

RELEASED
2011-01-10
MD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.85 lbs
- 8) WELD PER DART QSI 004.

| | | | |
|------------|----------|--|--------------|
| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D4278 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | RIB ASSEMBLY | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries